

Date: Monday, 12/01/2009 2:37:35 PM  
 User: Julie Dawson

## Process Sheet

Jude

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WELDMENT TOP PANEL
Job Number	: 44673-2		
Estimate Number	: 13030		
P.O. Number	:	Part Number	: D36505
This Issue	: 12/01/2009 S.O. No. :	Drawing Number	: D3650 REV.C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 43664	Material	:
Written By	:	Due Date	: 02/02/2009 Qty: 4 Um: Each
Checked & Approved By	: <u>JLO 09.01.13</u>		
Comment	: Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD Est Rev:C ecn1162 08-04-02 DD verified by: EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.8537 sf(s)/Unit Total : 3.4146 sf(s)  
 304/316 SS sheet 26 ga (0.018" thick)  
 Batch: 109398 B 9-1-21

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3650  
 Dwg Rev: C  
 Prog Rev: C

B 9-1-21

(6)

2-Deburr if necessary

B 9-1-21

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 9-1-21

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 09/01/21 (46)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 Form as per Dwg D3650

S 09/01/27

(6)

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 44673

Part Number: D36505

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sc 02/01/27 (X6)

7.0

D36507

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

SEAL

batch

35924 x 2 / 43821 x 2

FF 09/01/29

8.0

D36509

Angle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

ANGLE

batch

42097 x 1 / 43823 x 5

FF 09/01/29

9.0

AN660C4

WASHER



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

WASHER

batch

106431

M 106431

FF 09/02/02

10.0

NAS9307M403

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

RIVET

batch

1109680

M 109405

FF 09/02/02

11.0

MS20427M33

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Rivet

batch

M 110022

FF 09/01/29

12.0

MS210603K

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Nut Plate

batch

M 109371

FF 09/01/29



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3650-5 PAR #: N/A Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 09/02/04  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: D Date: 09/02/04

NCR <u>44673-2</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.01.29	9.0 + 10.0	MS 206153M15 PROVES TO BE TOO HARD TO INSTALL SINCE MATL THICKNESS IS VERY THIN (0.018"). ESTHETICALLY UNACCEPTABLE.	<u>1</u> 09.01.29	GO BACK TO INSTALLATION OF D3650-7-8.19 + D3650-4 TO D3650-5B PER REV. B	<u>SB</u> 09/02/03	<u>1090203</u>	<u>1</u> 09.01.29	<u>1</u> 09.02.03
			<u>CP</u> 09.02.03 per 081042	D3893-1 B75377 ADDED TO INCREASE THICKNESS. USED NAS9307M4M4 RIVETS BECAUSE OF INCREASED THICKNESS	<u>SB</u> 09/02/03	<u>1090203</u>	<u>CP</u> 09.02.03 per 081042	<u>1</u> 09.02.03
			<u>CP</u> 09.02.03 per	Acceptable to install 0.018" THICK AISI 304 SHEET DOUBLER TO INCREASE THICKNESS.	<u>SB</u> 09/02/03	<u>1090203</u>	<u>CP</u> 09.02.03 per	<u>1</u> 09.02.03

See NCR  
09-016

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 44673

Part Number: D36505

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

MS210623K

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)  
12

Nut Plate

batch 11109430x5 / ma09513x3

FF 09/01/29

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3650

FF 09/01/29

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/02/03

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: GA

D3650-011 B45306

SB 09/02/03

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/03

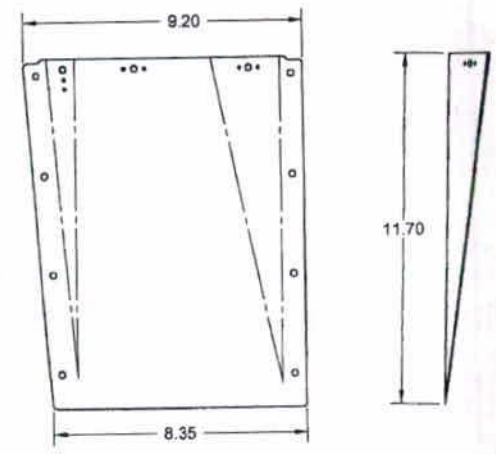
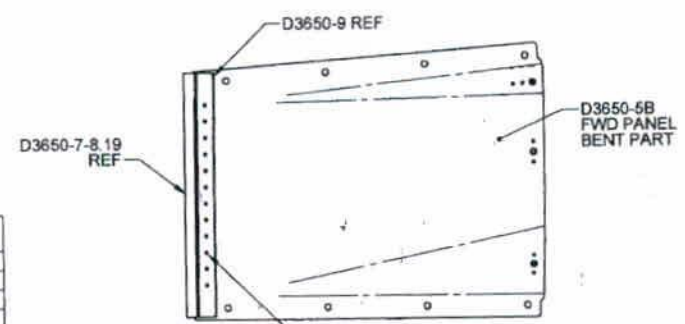
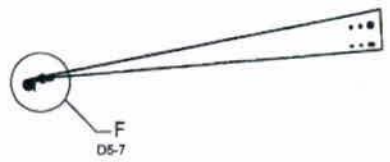
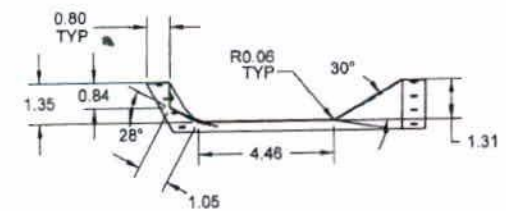
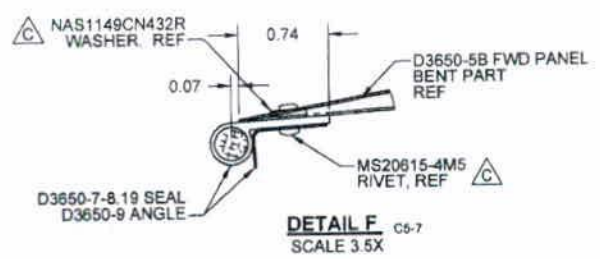
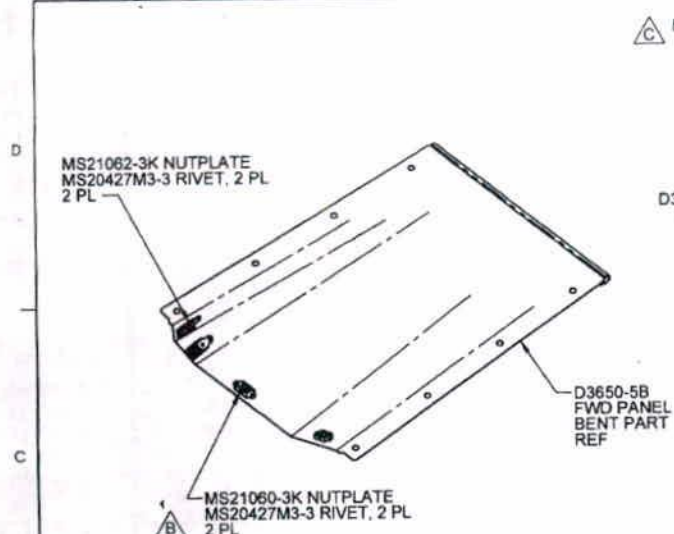
Job Completion



U 09.02.03







**PART LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8-19	SEAL
1	D3650-9	ANGLE
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

CENTRE D3650-7-9 ON D3650-5B & TRANSFER (2-1/2" DRILL) HOLES FROM D3650-9 TO D3650-7 & D3650-5B AS SHOWN  
INSTALL  
MS20615-4M5 RIVET  
NAS1149CN432R WASHER  
12 PL

0.048 (440)  
0.040128  
PDC 051043

**D3650-5B FWD PANEL BENT PART**  
(MAKE FROM D3650-5F FLAT PATTERN)

**RELEASED**  
08/11/17

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.8 lbs

**D3650-5 FWD PANEL**

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3650</b> TITLE <b>TOP PANEL ASSEMBLY</b> <small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>
DRAWN	RF	
CHECKED	RF	
MFG. APPR.		
APPROVED		
DE APPR.		REV. C
DATE	08.10.14	SHEET 7 OF 9
		SCALE NTS